

Date: Monday, 07/07/2008 11:11:09 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PEDAL LOCK BASE
Job Number : 40205	
Estimate Number : 10444	
P.O. Number :	Part Number : D33681
This Issue : 07/07/2008 S.O. No. :	Drawing Number : D3368 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 01/07/2008 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 23534	Material :
Written By : <i>[Signature]</i>	Due Date : 30/07/2008 Qty: <i>10</i> Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est. A 05.01.27 New issue KJ/JLM	

## Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :
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1.0	M6061T6B2000X02000	6061-T6 Bar 2.0" x 2.0"
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Comment: Qty.: 0.9277 f(s)/Unit Total : 5.5661 f(s)

6061-T6 Bar 2.0" x 2.0"

Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8)

(M6061T6B2.000x02.000)

Batch: *M13085* x 3

*M17124* x 4

*M17124* x 3

*N.A*

*08/07/10*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine D3368-1 as per Folio FA499 and Dwg D3368

Identify as D3368-1

Deburr

*(10)*

*SA 08/07/14*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



*(10)*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SA 08/07/14*

4.0	QC8	SECOND CHECK
-----	-----	--------------



*(10)*

Comment: SECOND CHECK

*mk 08/07/16*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



*(10)*

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*BR/212*

*08/07/17*

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK BASE

Job Number: 40205

Part Number: D33681

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M18052



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

10:00am

OVEN TEMPERATURE:

320°F

FINISH TIME:

10:30am

JL

08-07-17

(X10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



X10

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 491

8/7/17

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/18 JL

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08-07-18

6.1 add Qc3

perm. change

08/07/17

(10)

JL

08-07-17

DART AEROSPACE LTD		Work Order:	40205
Description: Pedal Lock Base		Part Number:	D3368-1
Inspection Dwg: D3368 Rev: B		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

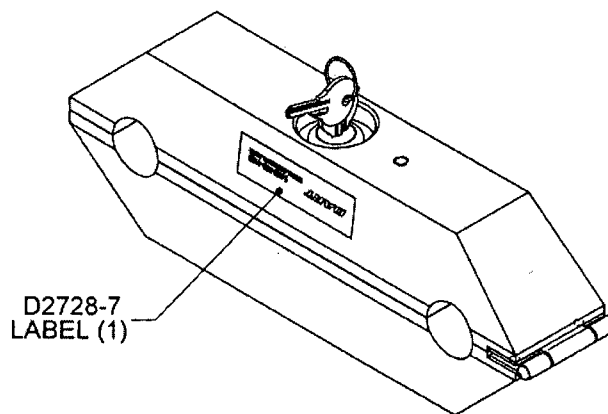
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.25	+/-0.030	10.255	/			
7.250	+/-0.010	7.250	/			
<del>0.700</del>	<del>+/-0.010</del>	N/A				
0.107	+/-0.010	0.107	/			
1.800	+/-0.010	1.800	/			
0.750	+/-0.010	0.750	/			
Ø1.031	+/-0.010	Ø1.128	/			
45°	+/-0.5°	45°	/			
0.250	+/-0.010	0.250	/			
2.00	+/-0.030	1.998	/			
7°	+/-0.5°	7°	/			
Ø0.230	+0.005/-0.000	0.230	/			
1.250	+/-0.010	1.250	/			
1.075	+/-0.010	1.079	/			
R0.500	+/-0.010	R.500	/			
0.375	+/-0.010	0.373	/			
0.310	+/-0.010	0.309	/			
1.450	+/-0.005	1.450	/			
0.375	+/-0.010	0.375	/			
5.125	+/-0.010	5.125	/			

Measured by: SA	Audited by: [Signature]	Prototype Approval:	N/A
Date: 08/07/14	Date: 08/07/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Dimensions and tolerances changed	KJ/JLM	[Signature]

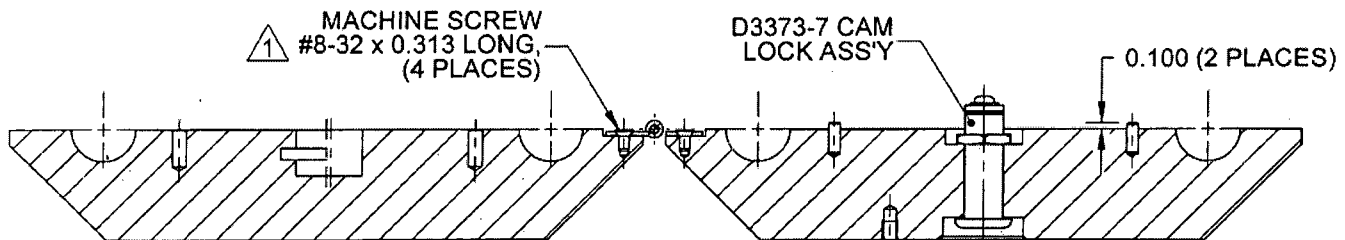


DESIGN 13	DRAWN BY 13	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED 13	DRAWING NO. <b>D3368</b>	REV. B SHEET 1 OF 3
DATE <b>05.03.22</b>		TITLE <b>PEDAL LOCK</b>	SCALE 1:3
A	05.01.19	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

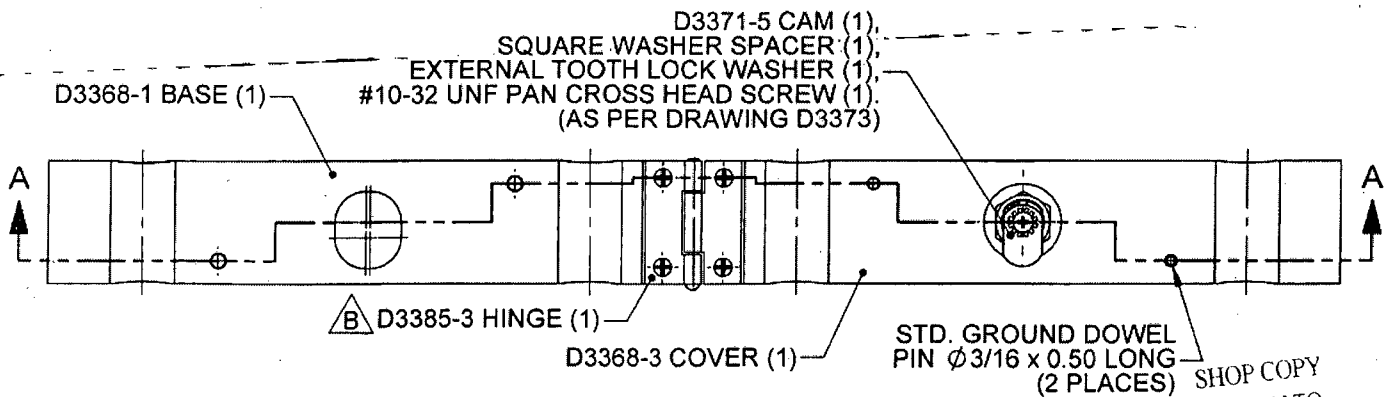


**RELEASED**  
25/04/28

**PEDAL LOCK SHOWN LOCKED WITH KEY**



**SECTION A-A**



**D3368-051 PEDAL LOCK ASSEMBLY**

**NOTES:**

- 1) POSSIBLE SUPPLIER: SPAENAU P/N 385-044
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

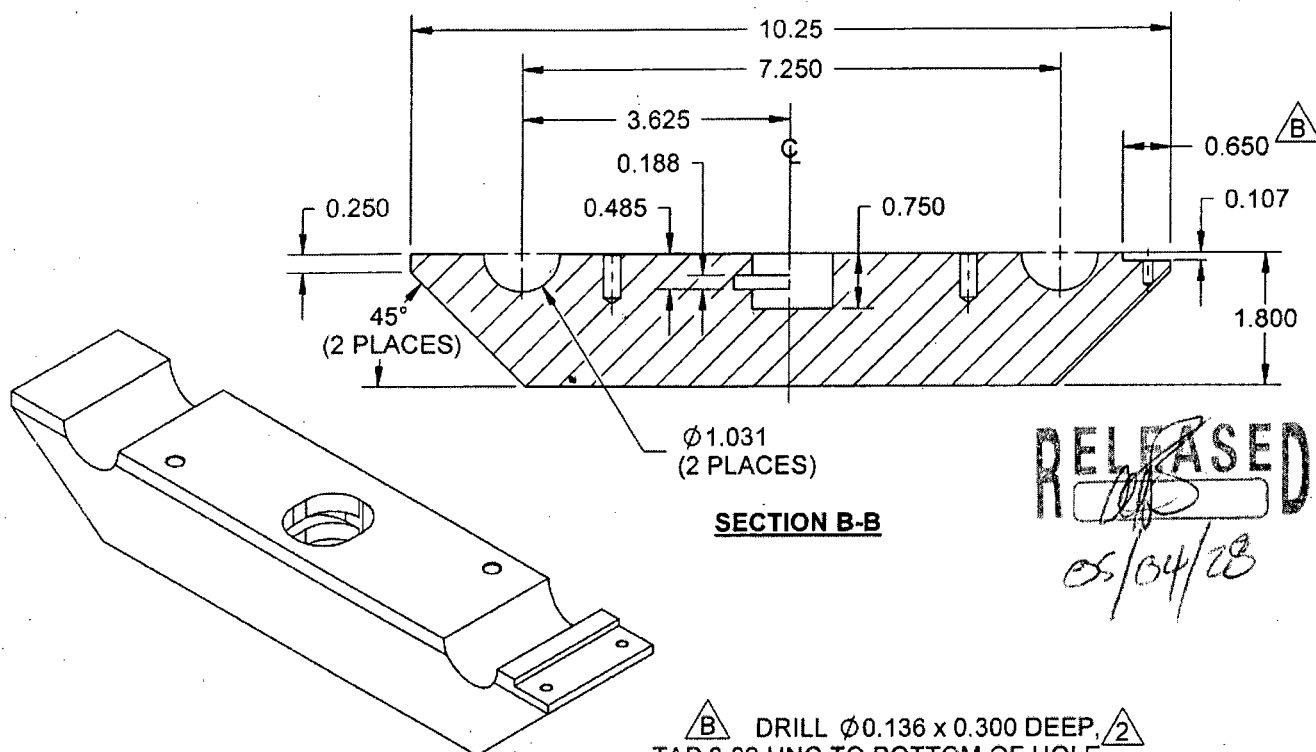
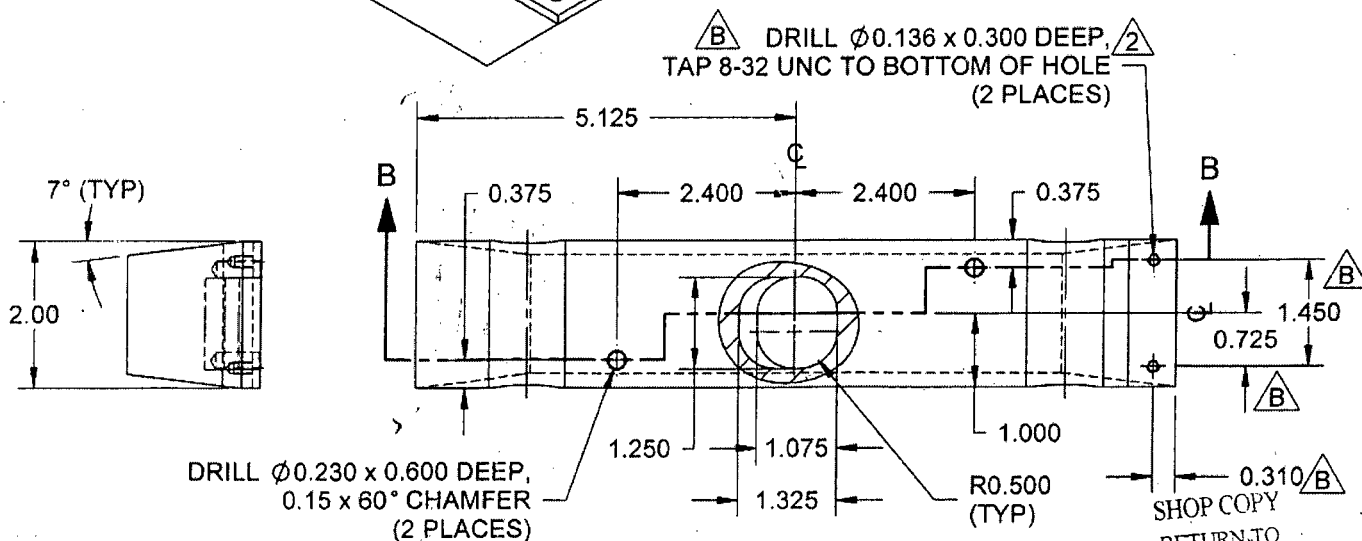
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3368</b>	REV. B SHEET 2 OF 3
DATE <b>05.03.22</b>		TITLE <b>PEDAL LOCK</b>	SCALE 1:2.5

**SECTION B-B****D3368-1 BASE****NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

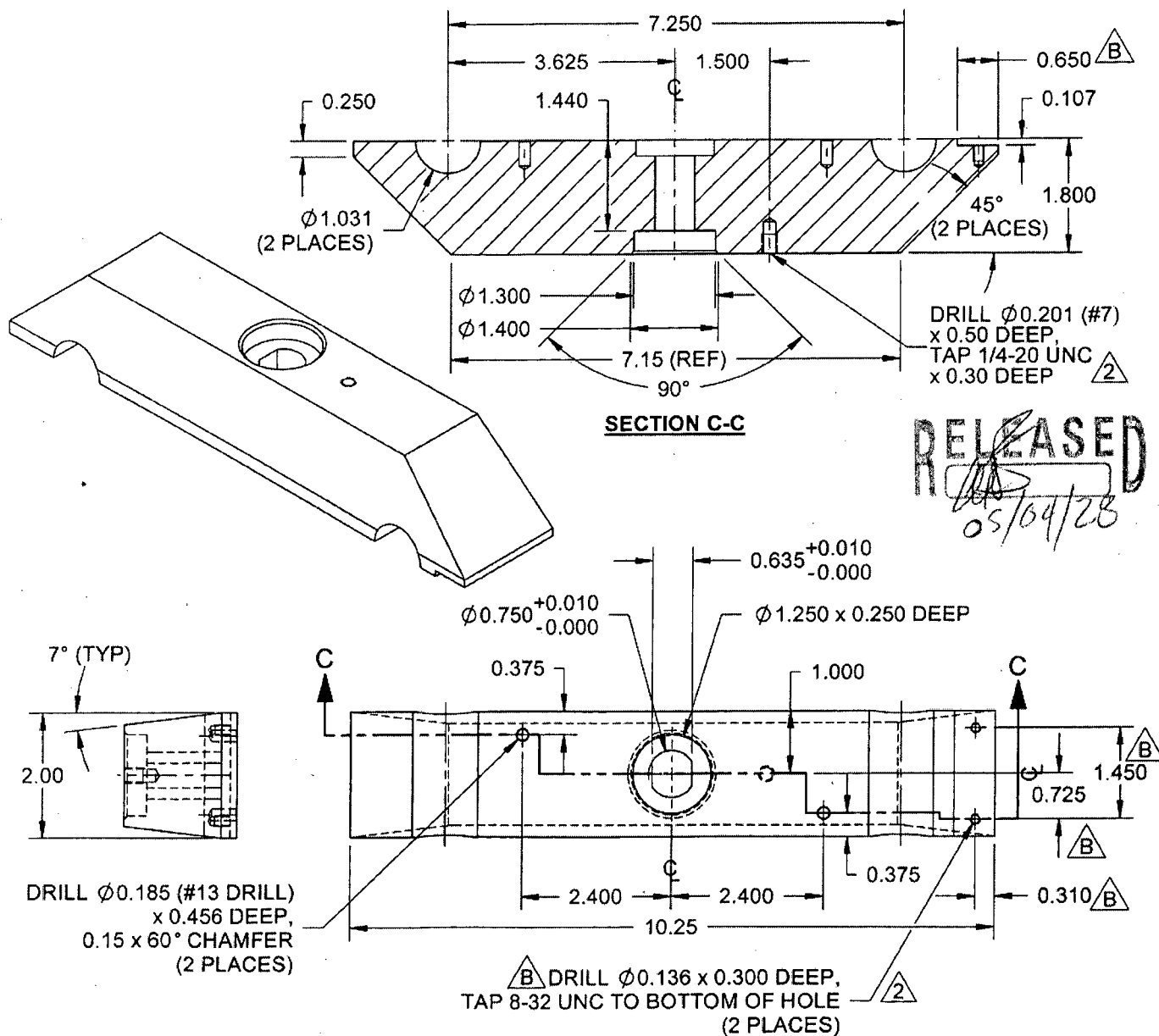
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3368</b>	REV. B SHEET 3 OF 3
DATE <b>05.03.22</b>	TITLE <b>PEDAL LOCK</b>	SCALE 1:2.5	



### D3368-3 COVER

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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